

ASAP Please

Work Order ID 68755

Thursday, April 21, 2011 8:26:33 AM



Item ID:	D3027-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Clip					
Start Date:	4/20/2011	Start Qty:	10.00	Cust Item ID:		
Required Date:	4/25/2011	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	1-04-21	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3027	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2024 .05C	1-Cut as per Dwg D3027								
	NOTE GRAIN DIRECTION**								
	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

1B11-4-27

31

1B11-4-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3027-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 4/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				count (31)			
130 Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form as per Dwg D3027	0.00 0.00				(31)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				count (31)			

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Page 3

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Required Date: 4/25/2011	Req'd Qty: 10.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				31	BR	11-4-28	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				31	ell	11/04/28	
170 Packaging Packaging	Identify as per dwg & Stock Location: 31 Memo	0.00 0.00					11/4/28	(310) J	

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Page 4

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Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 4/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/29

R 11-09-28
(30)

W/O:		WORK ORDER CHANGES					
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Thursday, April 21, 2011 8:26:40 AM

1. The first step is to identify the problem. This involves understanding the current situation and what needs to be changed.

2. The second step is to set goals. These should be specific, measurable, achievable, relevant, and time-bound.

3. The third step is to develop a plan. This involves identifying the resources needed and the steps to be taken.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves comparing the actual results with the goals and identifying areas for improvement.

6. The sixth step is to make adjustments. This involves making changes to the plan or implementation based on the evaluation.

7. The seventh step is to communicate the results. This involves sharing the findings with stakeholders and providing feedback.



8. The eighth step is to document the process. This involves recording the steps taken and the results achieved.

9. The ninth step is to review the process. This involves reflecting on the experience and identifying lessons learned.

10. The tenth step is to share the results. This involves presenting the findings to a wider audience and contributing to the knowledge base.

Required Qty: 10.00

Comments: IPP C05.10.07 Added forming step and Issue P/O KJ/JLM
IPP Rev:B Now on WaterJet 08-12-08 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	23.6488	0.024	0.252632	1.		
 													
2024-T3 .050 sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT22		23.648842							
				114968		23.648842							
										114968			

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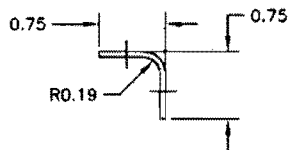
NOTE: Date & initial all entries

DART

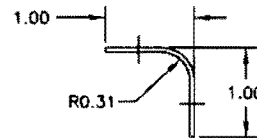
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DATE 05.09.20		TITLE CLIP	SCALE 1:2
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B	05.09.20	REMOVE HOLES FROM -7	

RELEASED

05.10.03

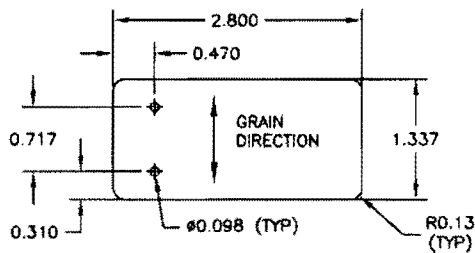
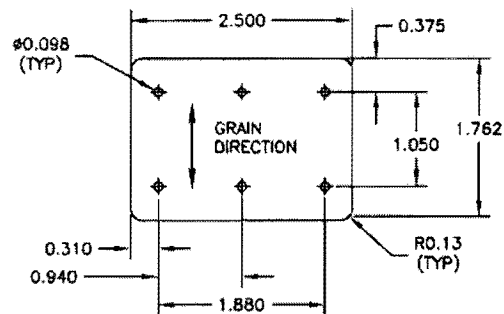


D3027-1 BEND DETAIL



D3027-3 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68755

11/11/04-21D3027-1 FLAT PATTERN
(0.063" SHEET)D3027-3 FLAT PATTERN
(0.050" SHEET)

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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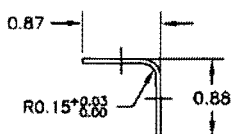
NOTE: Date & initial all entries



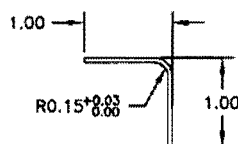
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3027	REV. B SHEET 2 OF 2
DATE 05.09.20		TITLE CLIP	SCALE 1:2

RELEASED

05.10.03 [Signature]

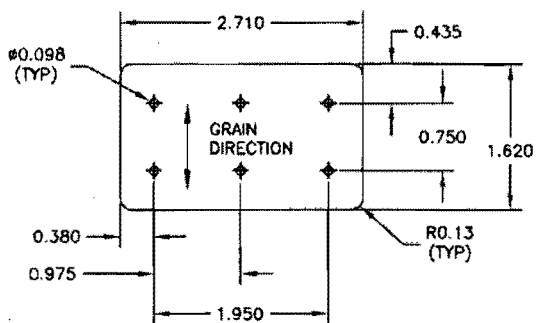


D3027-5 BEND DETAIL

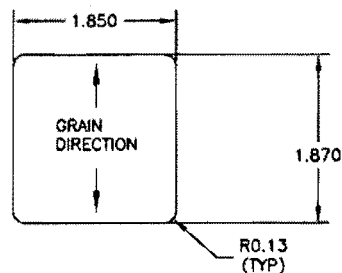


D3027-7 BEND DETAIL

u/o 68755



D3027-5 FLAT PATTERN
(0.050" SHEET)



D3027-7 FLAT PATTERN
(0.050" SHEET)

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